

Work Order ID 64118-2

Wednesday, November 24, 2010 2:50:00 PM

Page 1

Item ID: D3859-041

Accept

Revision ID:

Item Name: Wearplate

Start Date: 11/25/2010 Start Qty: 8.00

Required Date: 12/8/2010 Req'd Qty: 8.00

Reference:

Approvals:

Process Plan: *WMS*

Date: 11/24/10 Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

Draw Nbr

Revision Nbr

100

0.00



Waterjet

FLOW CNC Waterjet

304 . 063

FLOW WATER JET

Memo

1-Cut as per Dwg D3859 11 Dwg Rev: A 1 Prog Rev: A 12-  
Deburr if necessary

KB 10-11-25

110

0.00



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

Memo

0.00

KB 10-11-25

120

0.00



QC

Quality Control

QC8- Inspect parts - second check

Memo

0.00

Scrub 25

78

Work Order ID 64118

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Page 2

Item ID: D3859-041

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Start Date: 11/25/2010 Start Qty: 8.00

Required Date: 12/8/2010 Req'd Qty: 8.00

Reference:

Accept

Setup Start

Stop

Cust Item ID:

Customer:

Run Start

Stop

Approvals: Process Plan: Date: Tooling: Date:

QC: Date: SPC (Y/N): Date:

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

130



Large Fab

Large Fab

Large Fab

Memo

1-Weld D3009-3 cups as per dwg D3859 A/R 316L stainless steel rod  
Batch: M117649 12-Weld hard facing as per Dwg D3859 A/R  
2059B Hard Coat rod Batch: M116044 \*\*\*\*\*use  
DT9462 for welding\*\*\*\*\*

0.00

0.00

0.00

0.00

0.00

0.00

140



QC

Quality Control

QC9- Inspect visual per QSI004- Fusion Welds

Memo

150



QC

Quality Control

QC5- Inspect part completeness to step on W/O

Memo

M 10/11/25 2x

EC 10-11-26 (x2)

EC 10.11.26 (2x)

EC 10/11/26 (x2)

# Work Order ID 64118

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Reference:

Approvals: Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center ID

Operation  
Description

Set Up/  
Run Hours

Tool ID

Tool #

Plan  
Code

Accept  
Qty

Reject  
Qty

Reject  
Number

Insp.  
Stamp

160



Powdercoat

Powder Coating

Grey Sandtex(Ref:4.3.5.6) per QSI005 4.3

0.00

Memo

0.00

START TIME:

10:15  
300° FINISH TIME:

OVEN TEMPERATURE:

10:45.

2 BR 10-11-26

170



QC

Quality Control

QC3- Inspect Part Finish

0.00

Memo

0.00

=> 10/14/26

2 φ

180



Packaging

Packaging

Identify as per dwg & Stock Location:

0.00

Memo

0.00

10/14/26 (2)



**Work Order ID 64118**

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Page 4

Item ID: D3859-041

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Required Date: 12/8/2010 Req'd Qty: 8.00

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Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run Hours

Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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190

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

CK 10/11/29 [Signature]  
MF  
10-11-26

# Picklist Print

Wednesday, November 24, 2010 2:49:59 PM

Page 1

Work Order ID: 64118

Parent Item: D3859-041

Parent Item Name: Wearplate



Start Date: 11/25/2010

Required Date: 12/8/2010

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP Rev:A 09-02-03 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304S16GA

Purchased

No

100

sf

133.9000

0.85

6.8



304/316 Sheet .063



1850-11-26

Location

Loc Qty

Loc Code

MAT

133.9

111323

0

115688

2.9

115953

131

115953

8

D3009-3

Manufactured

No

130

Each

185.0000

6

48



EL 10-11-26

Cup

Location

Loc Qty

Loc Code

WA

185

42377

185

12





ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3859-041	WEARPLATE
2	1	D3859-1	WEARPLATE
3	6	D3009-3	CUP

2059B HARDCOAT  
10 PL

0.06  
TO  
0.13  
HIGH

C  
SYM

0.38

1.0  
TYP

3.1  
TYP

1.50  
REF

1.00

HARDCOAT WELD  
SURFACING  
REF

6 PL

1/32

6

D3859-1 WEARPLATE (1)

INSTALL D3009-3 FLUSH  
WITH THIS SURFACE  
TYP

D3009-3 CUP (6)

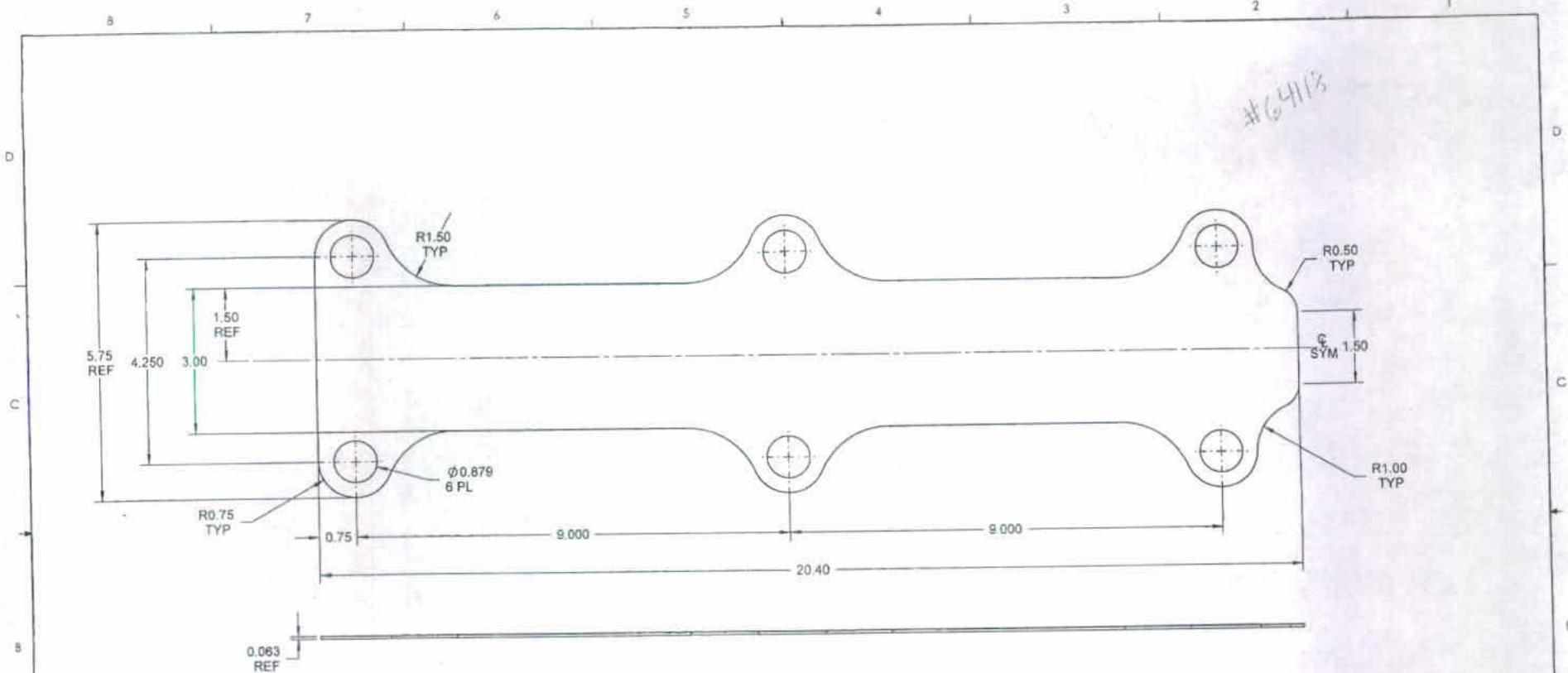
D3859-041 WEARPLATE

RELEASED  
09.01.26

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT "GREY SANDEXT" (4.3.5.6) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3859-041" & B/N USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 1.45 lbs
- 8) WELD PER DART QSI 004

A	NEW ISSUE	DESCRIPTION	BY	DATE
DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED				
MFG. APPR.				
APPROVED				
DE APPR.		DRAWING NO. D3859	REV. A	SHEET 1 OF 2
DATE	09.01.26	TITLE WEARPLATE	SCALE NTS	
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**D3859-1 WEARPLATE**

**RELEASED**  
# 09.01.26

- NOTES:**
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL SHEET, 16 GAUGE (0.063 THICK).  
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524 (REF DART SPEC M304S16GA)
  - 2) FINISH: N/A
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: N/A
  - 7) WEIGHT: 1.29 lbs

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D3859	SHEET 2 OF 2
APPROVED		TITLE	SCALE
DE APPR.		WEARPLATE	NTS
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